



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4859-1
Job Sheet 170287



Part No: D4859-1 Job Qty: 12 ea
Part Name: Bushing
Part Weight: 0 lbs Status: Scheduled Priority: Medium
Job Created: 1/12/18 Job Tracking No:
Due Date: 1/26/18 Created By: Mario Poulin
Type: Stock Description:
Note: DWG REV A IPP REV:A 13.05.27 AS PER DWG REV.A DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining-3		FL 18-1-30
100	Hardinge	12 pcs	1/26/18	1/26/18	0.00	0.83	Hardinge		FL 18-1-30
120	QC	12 pcs	1/26/18	1/26/18	0.00	0.00	QC8		A. 18-01-30
130	Packaging	12 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-2		5/22
140	QC21-SA	12 Ea	1/26/18	1/26/18	0.00	0.00	QC21		18/02/01

Part Op 100 - Machine as per folio FB191
Descriptions:

018
21
9-88
FEB 02 2018

57130

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.750	0	14	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.060Inches ± 0.005	0.065 0.055	0.059	
2	Bushing	0.322Inches ± 0.010	0.332 0.312	0.32	
3	Bushing	0.030Inches ± 0.010	0.040 0.020	0.03	
4	Bushing	20.000Degrees ± 0.500	20.500 19.500	20°	Angle
5	Bushing	0.750Inches + 0.008 - 0.001	0.758 0.749	0.745	Diameter
6	Bushing	0.425Inches + 0.000 - 0.002	0.425 0.423	0.4243	Diameter
7	Bushing	0.257Inches + 0.005 - 0.000	0.262 0.257	0.257	Diameter

WORK ORDER NON-CONFORMANCE / UPDATE

AEROSPACE

QA Closed:

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water let ☐ Engineering ☐ Machini ☐ ity ☐ Thermoformi ☐ er ☐ Large F ☐						
Date :		Step #:		QTY Eff						
Description Work Order Deviation										
Root Cause <table border="0" style="width:100%;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table> <table border="0" style="width:100%;"> <tr> <td style="width:50%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%; vertical-align: top;"> Temperature/Cu ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/ ☐ Inspection Incom ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Inco ☐ Drill Holes ☐ </td> </tr> </table> OTHER : ☐							Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cu ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/ ☐ Inspection Incom ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Inco ☐ Drill Holes ☐
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PART NO: D4859-1
 Original Serial #: S036735
 Revision:
 Operation:
 Change No:

Job No: 170287

Bushing

S036735

DART
 AEROSPACE
S036735

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Approval ☐

 By ☐

 Supervisor ☐

 Initiator ☐

 From ☐
 Extensions ☐
 Tolerance ☐
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